

Date: Tuesday, 1/9/2007 4:07:54 PM  
 U#: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 30221  
 Estimate Number : 12281  
 P.O. Number : N/A  
 This Issue : 1/9/2007 S.O. No. : N/A  
 Prsht Rev. : NC  
 First Issue : N/A Type : LARGE FAB ASSY  
 Previous Run : 29891

Drawing Name : RIGHT ARM WELDMENT

Part Number : D3354042  
 Drawing Number : D3354 REV.A  
 Project Number : N/A  
 Drawing Revision : A  
 Material : N/A  
 Due Date : 2/10/2007

Written By :                       
 Checked & Approved By :                       
 Comment : est rev. A 06.02.09 new issue EC

Qty: 3  
 Um: 4 Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D33549 handle socket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty part number description batch  
 1 D3354-9 Handle socket

329905

PPL 07.01.22

③

2.0 D33541 inner shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty part number description batch  
 1 D3354-1 Inner shaft

330109

PPL 07.01.22

③

3.0 D33547 left arm plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty part number description batch  
 1 D3354-7 Left arm plate

329904

PPL 07.01.22

③

4.0 D33543 shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

pick:

qty part number description batch  
 1 D3354-3 Shaft

329902-1

PPL 07.01.22

③

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 1/9/2007 4:07:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 30221

Part Number: D3354042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

TP134

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

TP-134 TENSION PIN

Batch: M16362

*Ppl 07-01-22*

(3)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354

2-Grind welds flush as per dwg D3354

*Ppl 07-01-22*

(3)

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*07/01/22 (3)*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*07/01/22 (3)*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

*FR/YH*

*07/01/22*

(3)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*07/01/22 (3)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 568

*07/01/22 (3)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:   *SD*   Date: 07/01/24  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 1/9/2007 4:07:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 30221

Part Number: D3354042

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

1/20/07/24

Job Completion



1/20/07/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

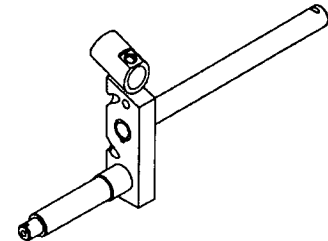
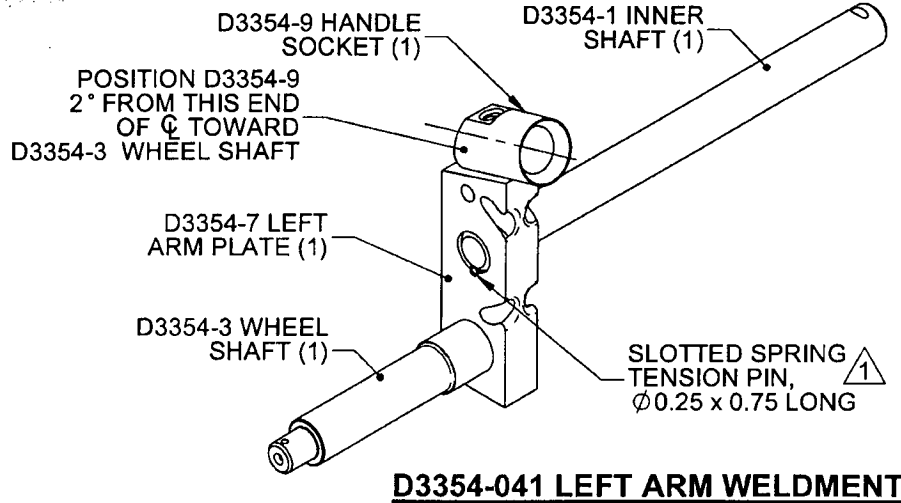
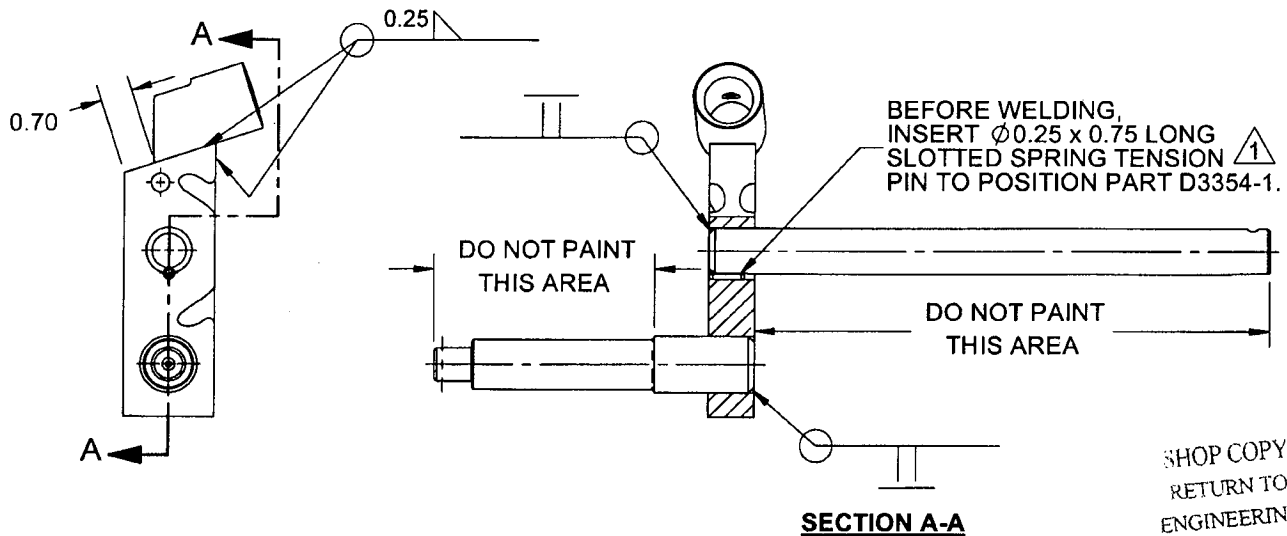
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED	DRAWING NO. <b>D3354</b>	REV. A SHEET 1 OF 7
DATE <b>04.12.13</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:4
A	04.12.13	NEW ISSUE	

**RELEASED**  
86/02/07**D3354-042 MIRROR  
ARM WELDMENT****NOTES:**

- 1) POSSIBLE SUPPLIER: SPAENAUR, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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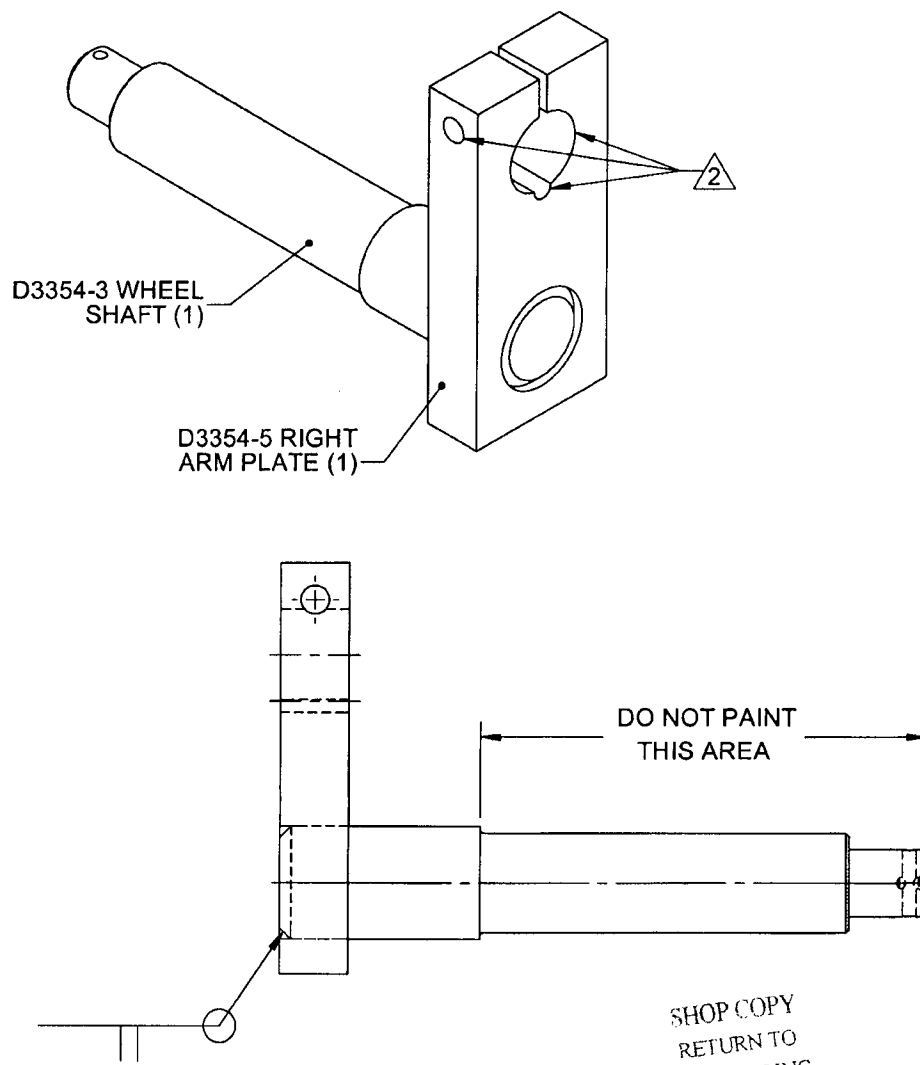
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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:2

**RELEASED**  
06/03/14

[Signature]

**D3354-043 RIGHT ARM WELDMENT****NOTES:**

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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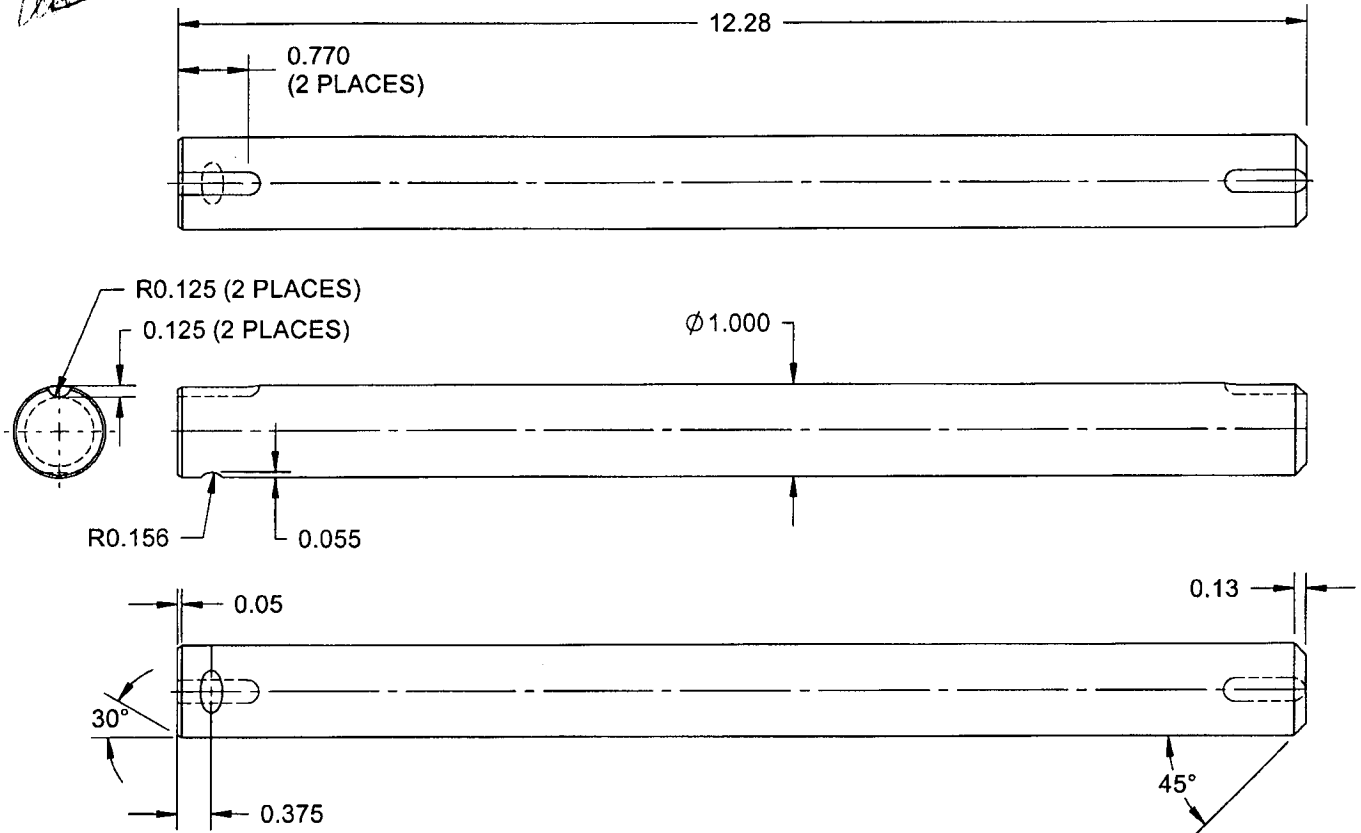
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DATE <b>04.12.13</b>		TITLE <b>LEFT ARM WELDMENT</b>	SCALE 1:2

**RELEASED**  
06/03/01  
*[Signature]***D3354-1 INNER SHAFT**

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**NOTES:**

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91  
OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

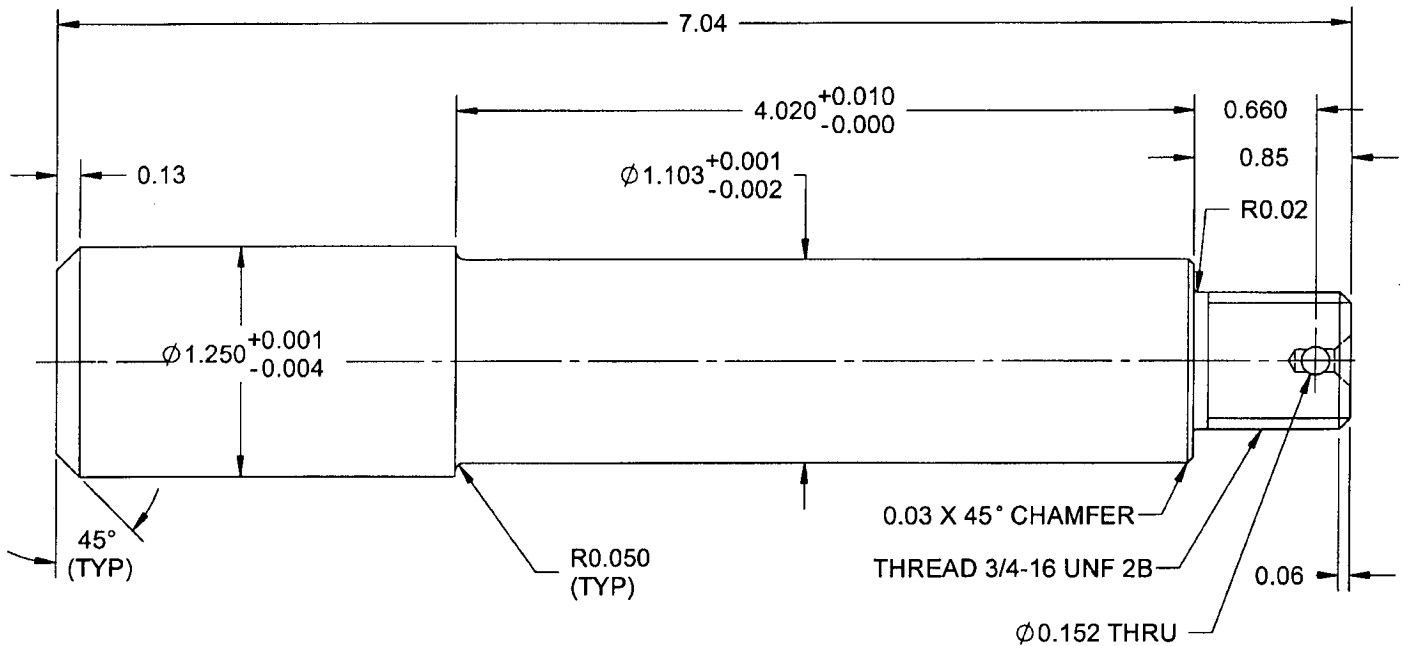
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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:1

**RELEASED**  
*[Signature]***D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

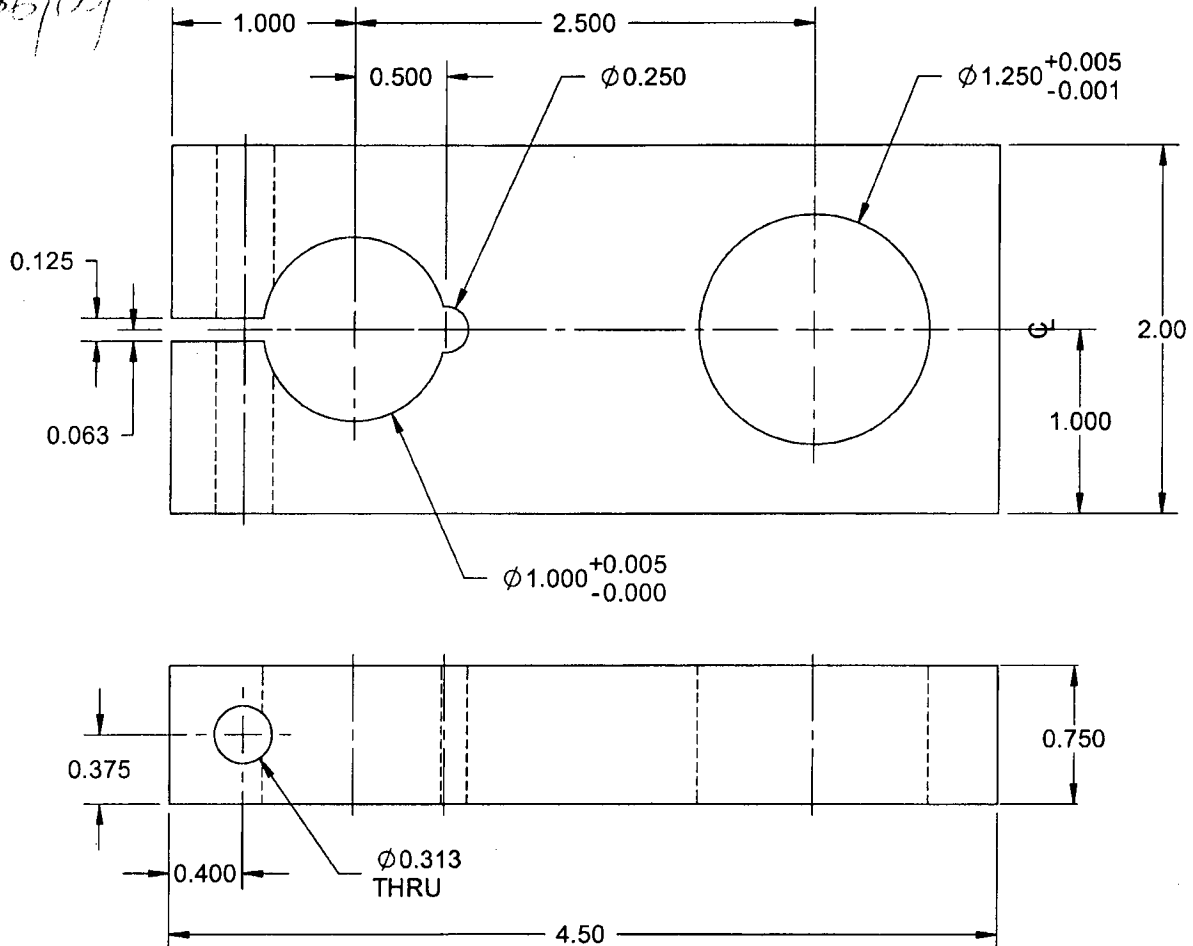
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DATE <b>04.12.13</b>	TITLE <b>LEFT ARM WELDMENT</b>		SCALE 1:1

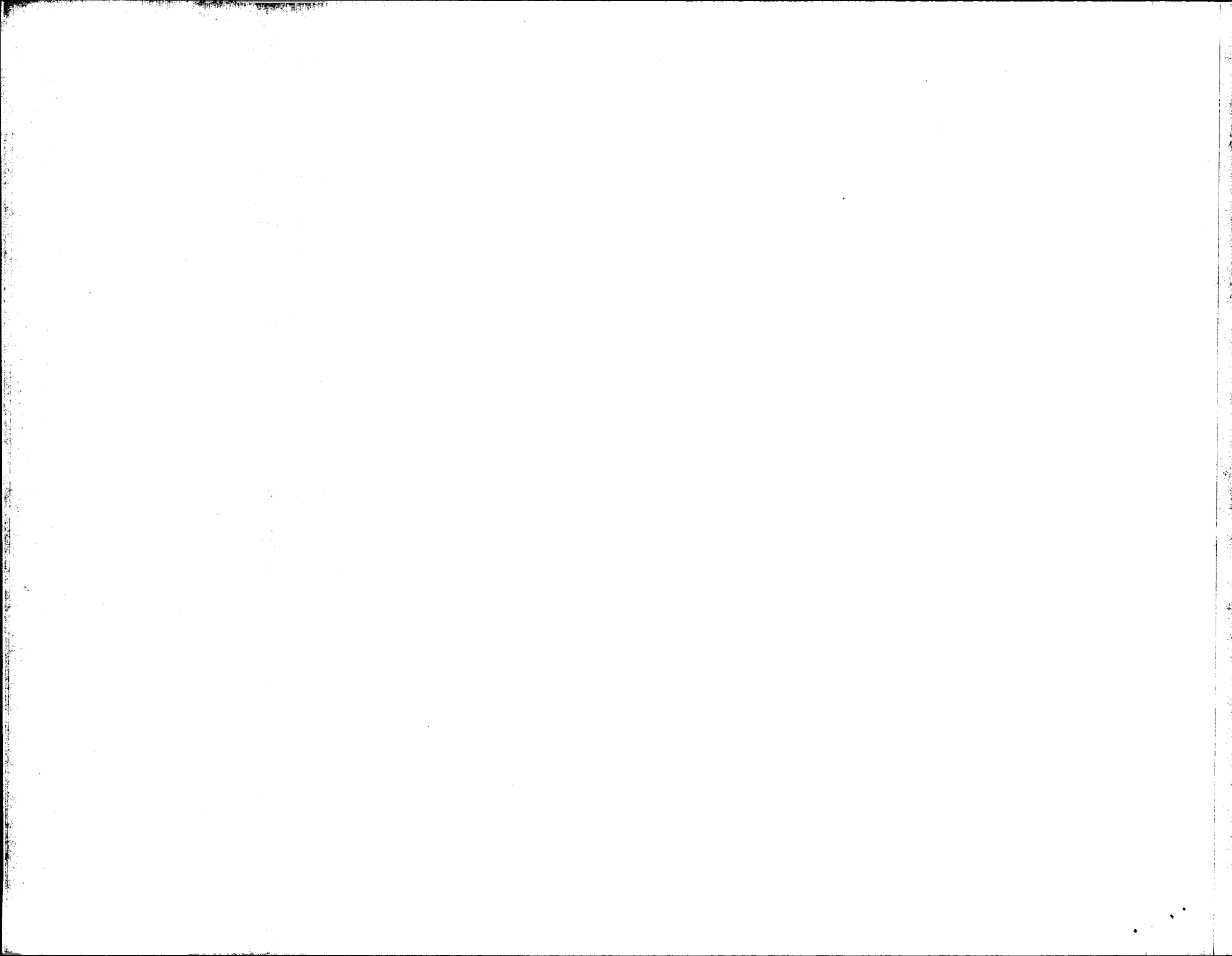
**RELEASED**  
*06/03/14***D3354-5 RIGHT ARM PLATE****NOTES:**

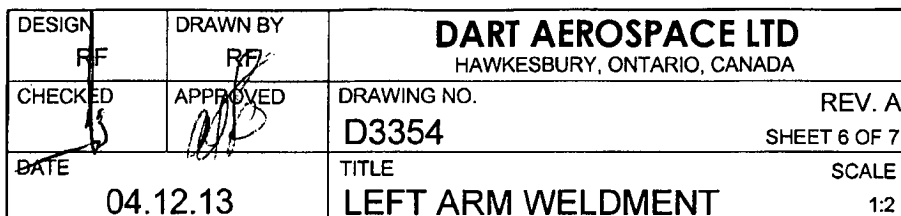
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD NO. 30221 STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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RELEASED  
2013/01



### D3354-7 LEFT ARM PLATE

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR  
CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD  
STEEL BAR (REF. DART SPEC. M1010-B)  
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
3) ALL DIMENSIONS ARE IN INCHES  
4) BREAK ALL SHARP EDGES 0.010 TO 0.020

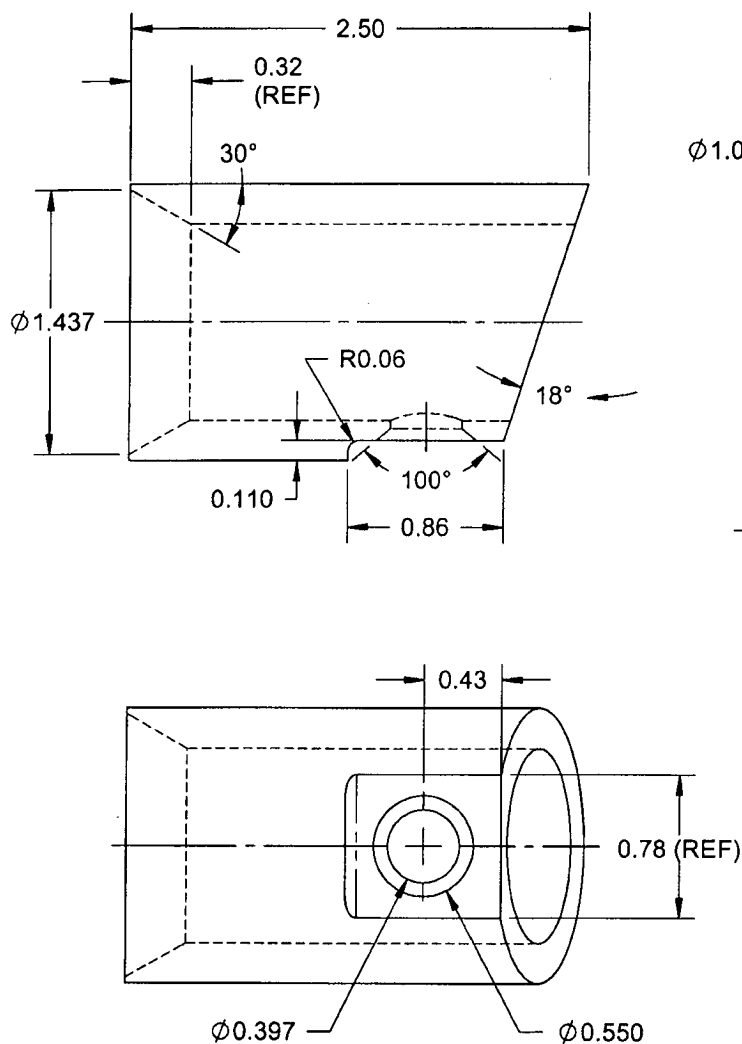
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3354	REV. A SHEET 7 OF 7
DATE 04.12.13	TITLE LEFT ARM WELDMENT		SCALE 1:1

**RELEASED**  
06/03/09**D3354-9 HANDLE SOCKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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